

Work Order ID 70693

Monday, June 13, 2011 1:34:14 PM



Page 1

Item ID: D2438

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 6/13/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 6-13-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2438

Rev C

100

0.00



PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D2438

304.033

prog rev: S

dwg rev: C

B11-6-15

[Signature]

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Ensure Material Release Note is attached

B11-6-15

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

(6.786" center to center)

Sub 116

cauto
X90
QSP019

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Use DT9713 clamp holder to hold clamp in place when forming
2- Bend as per dwg usind DT9709

SP 11/7/21

90

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

M

11

07

21

90

150

0.00



Identify as per dwg & Stock Location:

486

Packaging

Memo

0.00

Packaging

11/7/21

SP

90

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Required Date: 6/20/2011 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/22 [Signature]

11-07-21
[Signature]

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 1:34:21 PM

Page 1

Work Order ID: 70693

Parent Item: D2438

Parent Item Name: Clamp



Start Date: 6/13/2011

Required Date: 6/20/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP: E 05.06.28 Bending removed KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

119.1000

0.04

3.368421



304/316 Sheet .063



4.
B11-6-15

Location

Loc Qty

Loc Code

MAT020

119.1

117275

4.3

117653

114.8

117653

(90)

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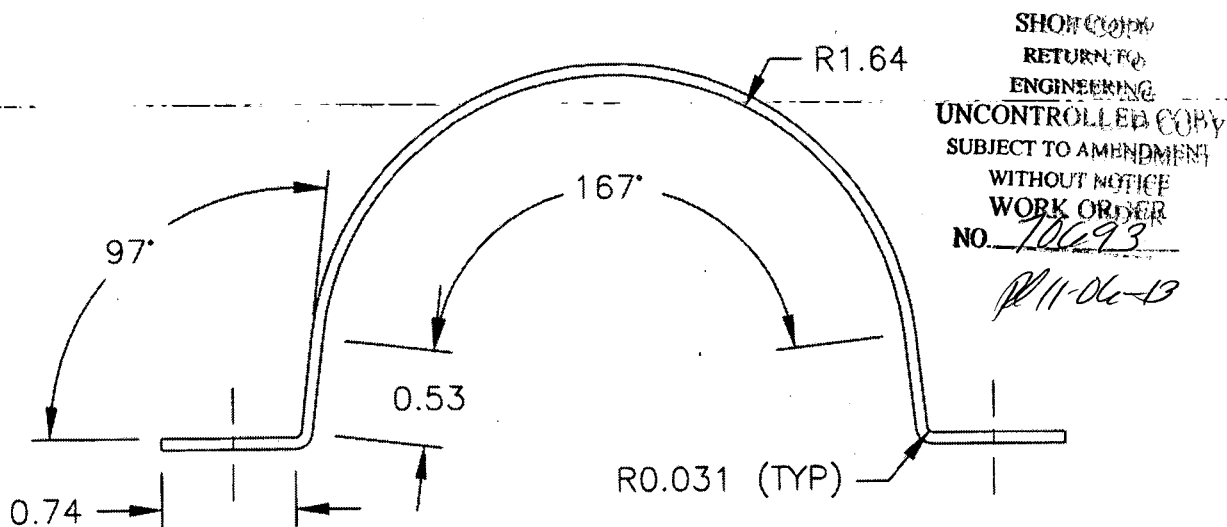
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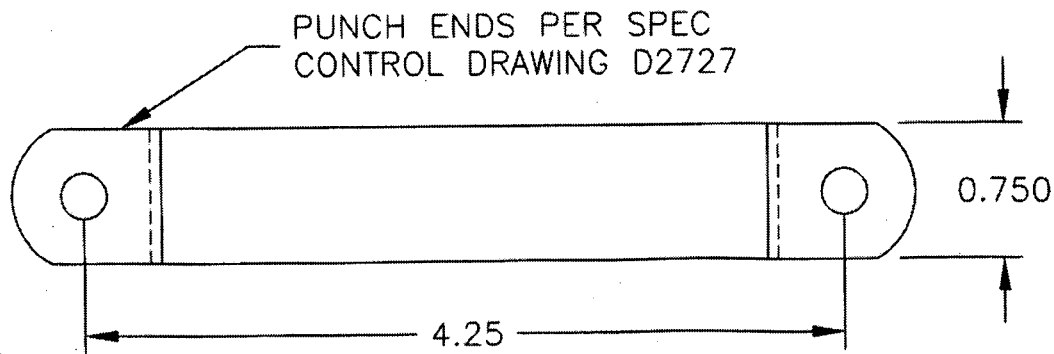


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
48.06.17 KE



SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70693
11-06-13



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

70
40
60

00.06.06
CP 00.06.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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